

Work Order ID 122493

Tuesday, July 22, 2014 8:38:06 AM

122493

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Item ID: 647.9202

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Cutter Assembly

Start Date: 7/21/14 Start Qty: 2.00

Cust Item ID:

Required Date: 7/21/14 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-07-22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.9200	N/C

110	Pick Kit	0.00							DAS 41 9-89
110						8			
Packaging	Memo	0.00							15-1-10
Packaging									

120		0.00							DAS 41 9-89
120						8			
Small Fab	Memo	0.00							15-1-10
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 2.								

A/R RTV LOCTITE 598: 125637
exp. date: 5/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Tuesday, July 22, 2014 8:38:06 AM

122493

Page 2

Item ID: 647.9202 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Cutter Assembly
 Start Date: 7/21/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/21/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00				(8)			DAS 38 9-89
130									
QC	Memo	0.00							
Quality Control									JAN 14 2015
140	Identify as per dwg & Stock Location <u>CCF12</u>	0.00				8			DAS 56 9-89
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS DWG PER APICAL MPP-120 BY LASER ETCH THE P# AND REV***								JAN 16 2015
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									MLJ 15-01-20

u 15-01-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY			
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Page 1

Work Order ID: 122493

122493

Parent Item: 647.9202

647 9202

Parent Item Name: Lower Cutter Assembly

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
601.2045		Purchased	No				Each	237.0000		2		DAS 41 9-89	
601 2045									**			15-1-10	
RTV (LOCTITE 598)													

Location	Loc Qty	Loc Code
CCK96	237	
125540	64	
125637	87	
126540	12	
m125792	74	

647.9410		Manufactured	No				Each	31.0000		2		DAS 41 9-89	
647 9410									**			15-1-10	
Lower Deflector													

Location	Loc Qty	Loc Code
MF	31	
103091	19	
109618	4	
m129311	8	

647.9701		Manufactured	No				Each	4.0000		2		DAS 41 9-89	
647 9701									**			15-1-10	
Lower Cutter Sub Assembly													

Location	Loc Qty	Loc Code
CCK48	4	
m129311	4	

128107

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 122493

Parent Item: 647.9202

Parent Item Name: Lower Cutter Assembly

122493

647 9202

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Purchased

No

Each

4,149.000

DAS

MS21042I 08

Nut

**

41

9-89

15-1-10

Location

Loc Qty

Loc Code

ST306

4149

123900

1

125445

268

m127304

99

m127410

1398

m128407

1500

m128429

683

m129541

200

130325

3

21 + 3 scrap

MS27039-08-19

Purchased

No

Each

1,378.000

DAS

MS27039-08-19

Screw

**

41

9-89

15-1-10

Location

Loc Qty

Loc Code

ST506

1378

124309

25

125654

78

m127410

275

m127904

1000

130505

24 + 3 scrap

NAS1149FN832P

Purchased

No

Each

7,774.000

DAS

NAS1149FN832P

Washer

**

41

9-89

15-1-10

Location

Loc Qty

Loc Code

ST275

7774

123185

30

123522

400

123900

2

125268

7342

130388

48

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Shop Packet Print

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DQA: _____ Date: _____



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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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A/R	A/R	A/R	9	601.2045	RTV	LOCITE 998	
3	3	3	8	601.1541	LOCKNUT	MS21042108	
6	6	6	7	601.2764	WASHER	NAS1149FN832P	
3	3	3	6	601.2765	SCREW	MS27039-D819	
			7	647.9411	UPPER DEFLECTOR		
			4	647.9410	LOWER DEFLECTOR		
			3	647.9702	UPPER CUTTER SUB ASSY		
			2	647.9701	LOWER CUTTER SUB ASSY		
			1	647.9402	LOWER DEFLECTOR LONG ASSY		
				647.9203	LOWER CUTTER LONG ASSY		
				647.9202	LOWER CUTTER ASSY		
				647.9201	UPPER CUTTER ASSY		
9203	9202	9201	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY			PART LIST				
NEXT ASSY (S)			ORIGINAL DATE LOCATED BY DRAWN BY AL. COLIN CHECKED BY P. BRADY DESIGNED BY P. BRADY DATE OF ISSUE 08-01-00 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE 16ths HOLE DRILLS ARE 1/16" DIA HOLE LOCATIONS ARE 0.001 TOLERANCE 0.001 UNLESS OTHERWISE SPECIFIED 30				
647.8900			APICAL INDUSTRIES 2808 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5363 CUTTER ASSY				
			SIZE B SCALE DIN A6 SCALE NONE				
			DRAW NO 647.9200 SHEET OF 1				